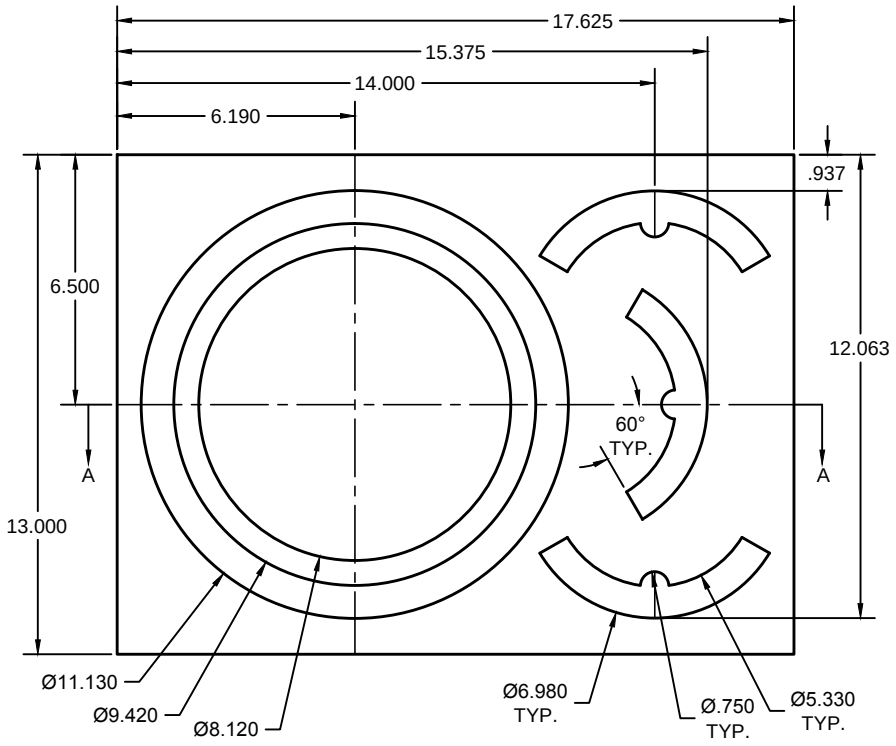
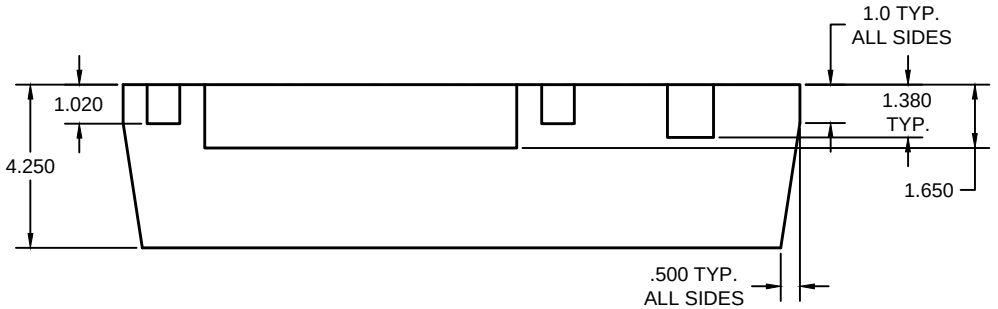
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED





PART #	QTY	DESCRIPTION
-6A	1	BOTTOM POLYETHYLENE FOAM 13 x 1-1/4 x 17-5/8 LONG
-6B	1	TOP POLYETHYLENE FOAM 12-3/4 x 1/2 x 17-3/8 LONG (NOT SHOWN)

USED ON MODEL
CH-47D

DRAWN BY: PERRITT
APPROVED
HEAT TREAT
FINISH SPEC --

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
.XXX ± .005
.XX ± .01
.X ± .1
FRACTIONS ± 1/32
ANGLES ±.5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

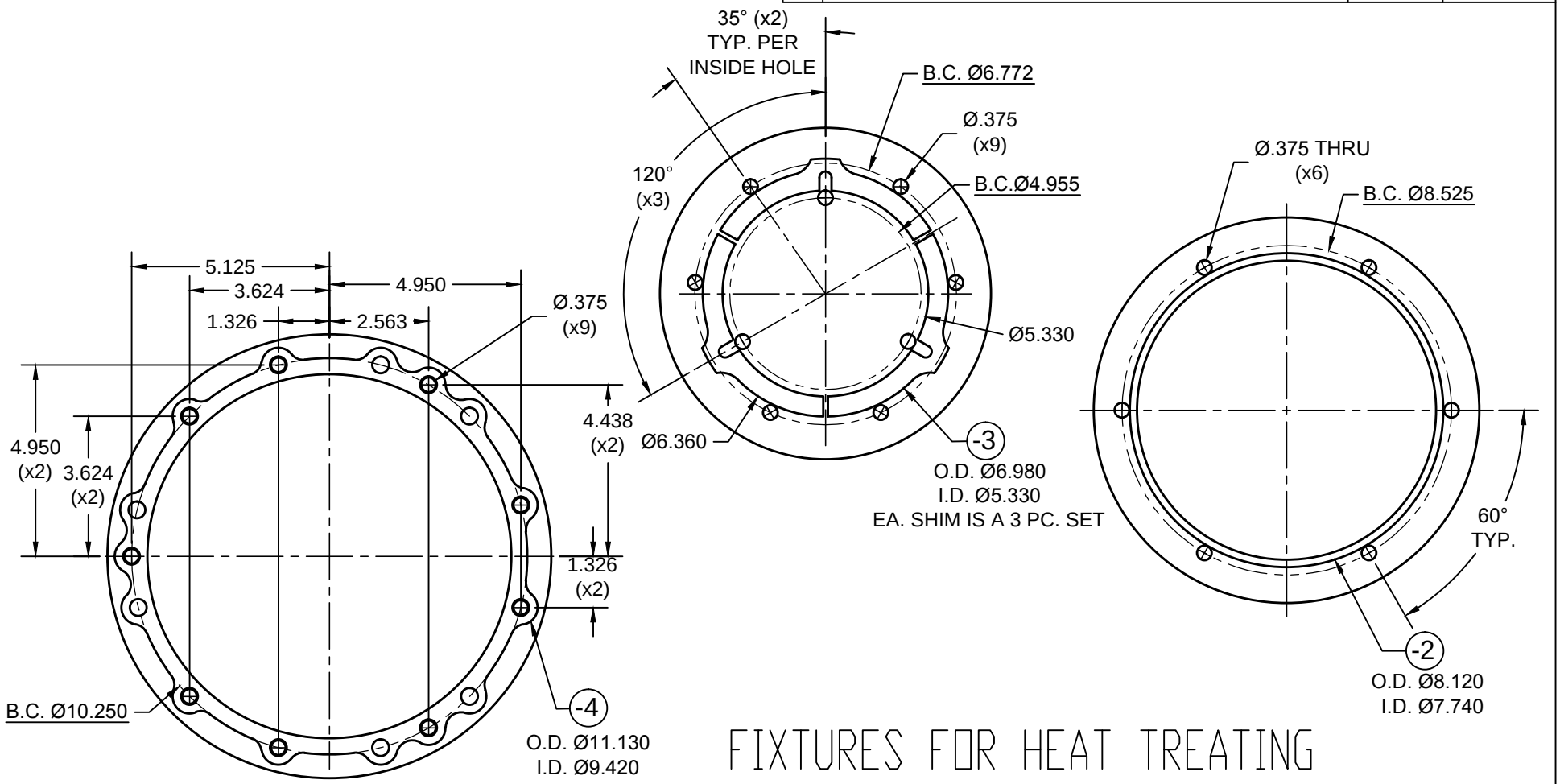
RED BARN MACHINE

TITLE
SHIM SET

DWG NO. 145G0287 REV

SCALE NTS DATE 5-1-06 SHEET 4 OF 4

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



FIXTURES FOR HEAT TREATING

PART #	QTY	DESCRIPTION
-2	17	SHIM SET
-3	34	SETS OF THREE SHIM SET (TOTAL 102 PCS.)
-4	30	SHIM SET

USED ON MODEL
414-100
CH-47D

DRAWN BY: PERRITT
APPROVED
HEAT TREAT
FINISH SPEC --

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
.XXX ± .005
.XX ± .01
.X ± .1
FRACTIONS ± 1/32
ANGLES ±.5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

RED BARN MACHINE

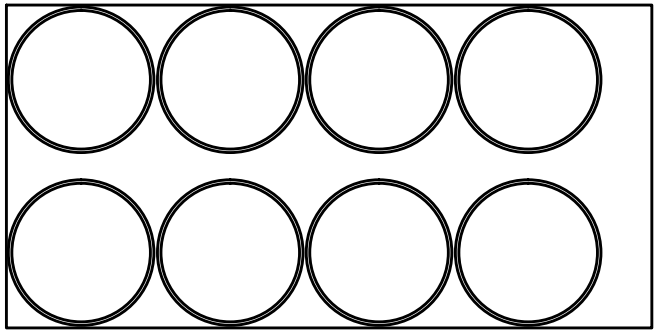
TITLE
SHIM SET FIXTURE

DWG NO. 145G0287 REV

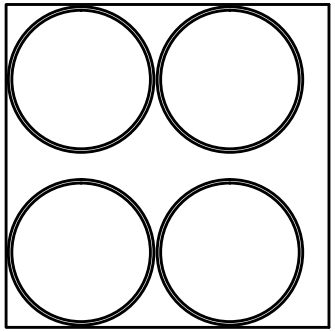
SCALE NTS DATE 4-17-06 SHEET 1 of 1

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

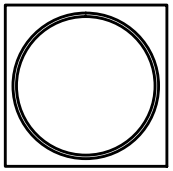
.125 SHEET THICKNESS



18 x 36

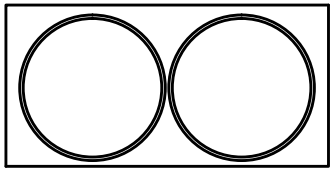


18 x 18



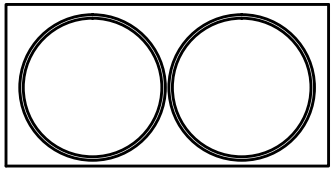
9 x 9

.190 SHEET THICKNESS



9 x 18

.250 SHEET THICKNESS



9 x 18

BURN SHEETS FOR -2

NOTES

INSIDE DIMENSION TO BE BURNED AT ø7.740,
THEN MACHINE TO ø7.805 $^{+.002}_{-.000}$

PART #	QTY	DESCRIPTION
-2	1	4130 .125 x 18 x 36 SHEET METAL
-2	1	4130 .125 x 18 x 18 SHEET METAL
-2	1	4130 .125 x 9 x 9 SHEET METAL
-2	1	4130 .190 x 9 x 18 SHEET METAL
-2	1	4130 .250 x 9 x 18 SHEET METAL

USED ON MODEL
414-100
CH-47D

DRAWN BY: PERRITT
APPROVED
HEAT TREAT
FINISH SPEC --

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
.XXX ± .005
.XX ± .01
.X ± .1
FRACTIONS ± 1/32
ANGLES ±.5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

RED BARN MACHINE

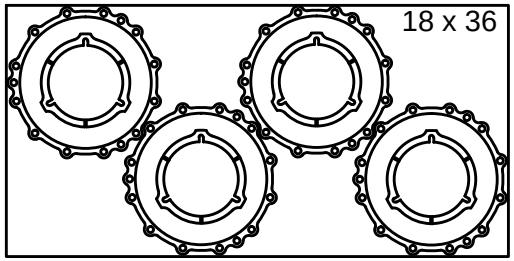
TITLE: SHIM SET

DWG NO. 145G0287 REV

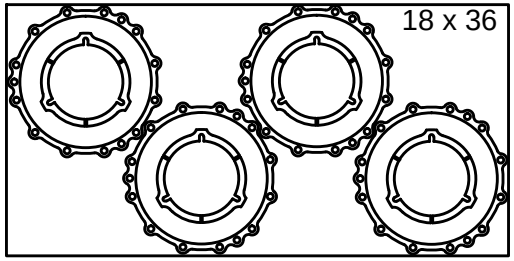
SCALE NTS DATE 2-7-06 SHEET 3 of 4

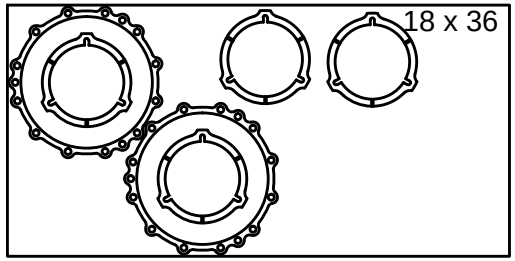
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

.025 SHEET THICKNESS

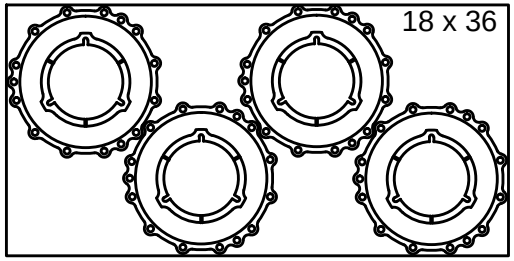


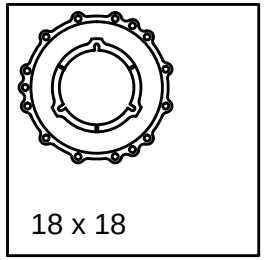
.032 SHEET THICKNESS



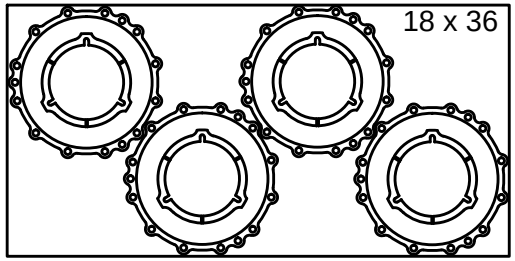


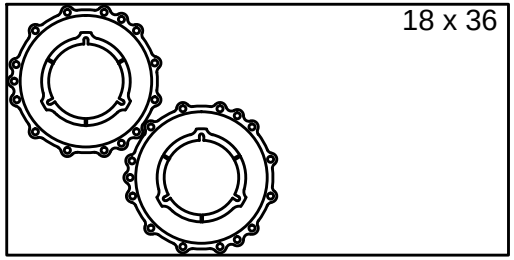
.040 SHEET THICKNESS



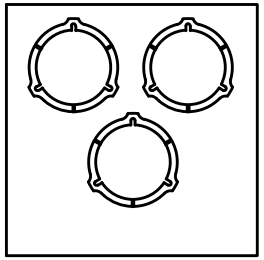


.063 SHEET THICKNESS

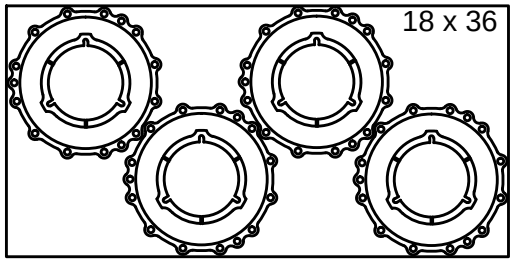


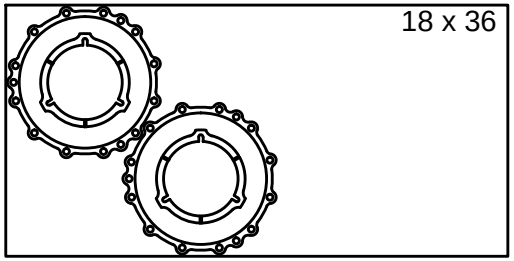


.090 SHEET THICKNESS

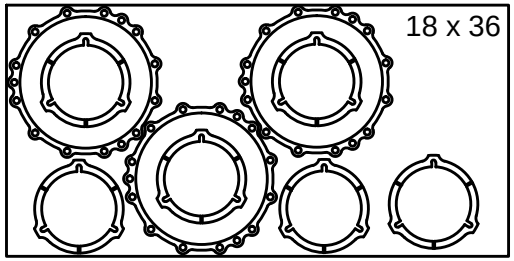


.071 SHEET THICKNESS





.080 SHEET THICKNESS



BURN SHEETS FOR -3 & -4

PART #	QTY	DESCRIPTION
--3&-4	1	4130 .025 x 18 x 36 SHEET METAL
--3&-4	2	4130 .032 x 18 x 36 SHEET METAL
--3&-4	1	4130 .040 x 18 x 36 SHEET METAL
--3&-4	1	4130 .040 x 18 x 18 SHEET METAL
--3&-4	2	4130 .063 x 18 x 36 SHEET METAL
--3&-4	2	4130 .071 x 18 x 36 SHEET METAL
--3&-4	1	4130 .080 x 18 x 36 SHEET METAL
--3	1	4130 .090 x 18 x 18 SHEET METAL

USED ON MODEL
414-100
CH-47D

DRAWN BY: PERRITT

APPROVED

HEAT TREAT

FINISH SPEC --

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
.XXX ± .005
.XX ± .01
.X ± .1
FRACTIONS ± 1/32
ANGLES ±.5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

RED BARN MACHINE

TITLE

SHIM SET

DWG NO. 145G0287

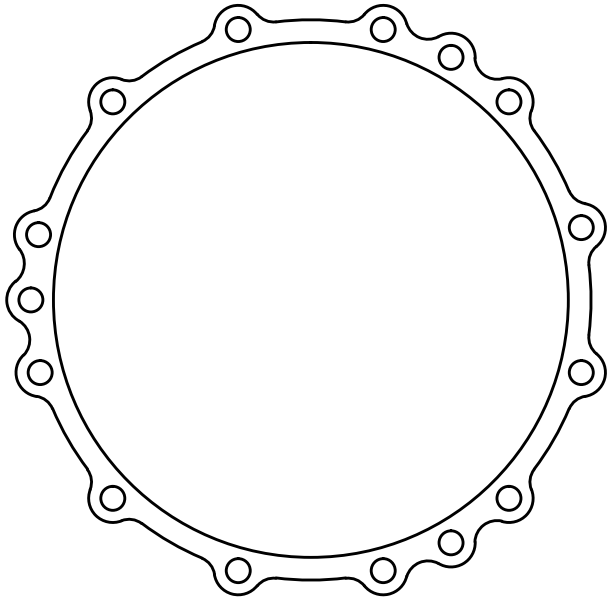
REV

SCALE NTS

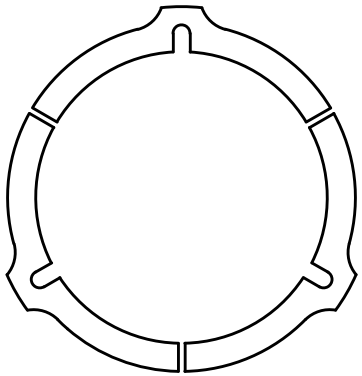
DATE 2-7-06

SHEET 2 of 4

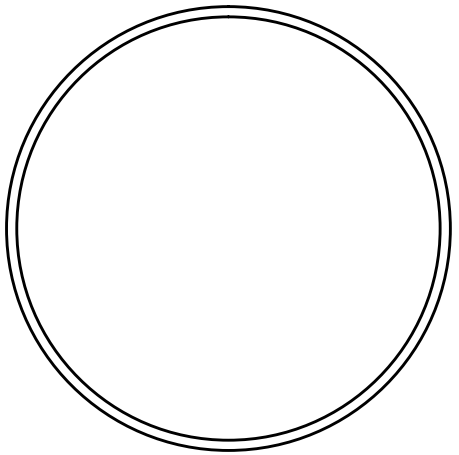
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



-4



-3



-2

PART #	QTY	DESCRIPTION
-2	17	SHIM SET
-3	34	SHIM SET
-4	30	SHIM SET

USED ON MODEL
414-100
CH-47D

DRAWN BY: PERRITT

APPROVED

HEAT TREAT

FINISH SPEC --

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
.XXX ± .005
.XX ± .01
.X ± .1
FRACTIONS ± 1/32
ANGLES ±.5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

RED BARN MACHINE

TITLE

SHIM SET

DWG NO. 145G0287

REV

SCALE NTS

DATE 2-7-06

SHEET 1 of 4

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	41L40 Ø5/8 x 3/4

USED ON MODEL
414-100
CH-47D

DRAWN BY: PERRITT

APPROVED

HEAT TREAT

FINISH SPEC: BLACK OXIDE

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
.XXX ± .005
.XX ± .01
.X ± .1
FRACTIONS ± 1/32
ANGLES ±.5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

RED BARN MACHINE

TITLE: TITLE

DWG NO.: PART #

RI

SCALE: NTS

DATE: 9-15-03

SHEET: 1 of 1

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

NOT APPROVED FOR PRODUCTION

PART #	QTY	DESCRIPTION
-1	1	4140 3/16 x 1 1/2 x 4

USED ON MODEL
414-100
CH-47D

DRAWN BY: PERRITT

CHECKED

HEAT TREAT

FINISH SPEC

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
.XXX ± .005
.XX ± .01
.X ± .1
FRACTIONS ± 1/32
ANGLES ±.5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

RED BARN MACHINE

TITLE

TITLE

DWG NO. PART #

REV.

SCALE NTS

DATE 9-15-03

SHEET 1 of 1